



Aralia Leaf

The large leaf cast in Colour de Verre's Aralia Leaf mold can be left flat; slumped individually into a small plate or bowl; or grouped with multiple Aralia Leaf castings to form large, dramatic decorative platters and bowls.



The design for the Aralia Leaf looks tropical, but the plant actual thrives in the American Pacific Northwest. The mold started as pristine leaf selected from one of these plants. A plaster duplicate was made so the delicate details could be refined. Through a back-and-forth of positive and negative models, the Colour de Verre mold emerged.

Priming the Mold

Always start by priming your molds. There are two products you

can use: Hotline Primo Primer™ and ZYP BN Lubricat (formerly MR-97).

With either product, clean the mold with a stiff nylon brush and/or toothbrush to remove any old kiln wash or boron nitride. (This step can be skipped if the mold is brand new.)

If you are using Hotline Primo Primer, mix the product according to directions. Apply the Primo Primer™ with a soft artist's brush and use a hair dryer to completely dry the coat. Give the mold four to five thin, even coats drying each coat with a hair dryer before applying the next. Make sure to keep the Primo well stirred as it settles quickly. The mold should be totally dry before filling. There is no reason to pre-fire the mold.

The first time ZYP is used on a mold, it is necessary to apply two coats of the product. Hold the can 10 to 12 inches from the mold. Apply the first, light coat using a four to five-second burst of spray in a sweeping pattern across all the mold's cavities. Do not saturate the surface. Set the mold aside for five minutes so it can dry. Once dry, apply a second coat using another four to five-second burst of spray. Let the mold dry for ten to fifteen

minutes. The mold is ready to fill. ZYP will result in fewer casting spurs and crisper detail.

See our website's Learn section for more instructions about priming Colour de Verre molds with ZYP.

Filling the Aralia Leaf

The suggested fill weight for the Aralia Leaf mold is 350 to 400 grams.

To accentuate the mold's details, one to two grams of Black powder is sifted into the mold. Before opening the bottle, put on a dusk mask as it always best to wear a dust mask when working with glass powders or other fine particles.



Place a small sifter on a piece of paper and load the sifter with some of the mixture. Hold the sifter over the mold and tap the sifter to distribute a fine layer over the mold's surface. Use a small paintbrush to brush away any er-

Availability

Colour de Verre molds are available at fine glass retailers and many online merchants including our online store, www.colourdeverre.com.

Tools

- ✓ Colour de Verre Aralia Leaf mold
- ✓ Medium primer brush
- ✓ Digital scale
- ✓ Sifter
- ✓ Assorted measuring spoons

Supplies

- ✓ Hotline Primo Primer™ or ZYP BN Lubricat (formerly MR-97)
- ✓ Assorted powder and fine frits

rant powder from the mold's top edge.

In a large, lidded container, combine 200 grams of fine Ming Green frit and 200 grams of fine Citron frit. Shake the container. Since glass dust is created by mixing the two frits, put on a dust mask before opening the container.

Use a small spoon to layer the frit mixture into the mold. Apply the first three-quarters of the frit mixture evenly into the mold without disturbing the powder. Use the last one-quarter of the frit to increase the frit depth around the leaf's center.



Fire the mold according to the Casting Schedule. The firing schedule's low target temperature and long hold will prevent the frit from becoming too liquid and balling up due to surface tension.

Slumping Individual Leaves

Individual leaves can be slumped into beautiful pieces by placing cast leaves in a Colour de Verre 7-10" Bowl Slump Form and using the Individual Leaf Slumping Schedule below.



Creating Larger Pieces

Multiple leaves can be tack fused to one another and then shaped.

To tack fuse multiple pieces together, start by protecting the kiln shelf with a good shelf primer (e.g. Hotline Primo™ Primer) or shelf paper (e.g. ThinFire™). Overlap the pieces in a pleasing manner and fire according to the Multiple Leaf Tack Fusing Schedule.

Once the combined leaves have cooled, place them in a large slumping form and fire according to the Combined Multiple Leaf Slumping Schedule.

When tack fusing or slumping combined leaves, it is important to

Casting Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1300-1320°F/705-715°C	45-60 minutes
2	AFAP	960°F/515°C	60 minutes
3	100°F/60°C	700°F/370°C	Off. No venting

* Schedule for COE 96. For COE 90, increase casting temperature by 15°F/8°C. AFAP means "As Fast As Possible", no venting.

Individual Leaf Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	300°F/165°C	1200-1210°F/650-655°C	10 minutes
2	AFAP	960°F/515°C	60 minutes
3	100°F/60°C	700°F/370°C	Off. No venting

* Schedule for COE 96. For COE 90, increase casting temperature by 15°F/8°C. AFAP means "As Fast As Possible", no venting.

follow the slow ramps. The larger piece will have a wide range of thicknesses and can crack if ramp speeds are too rapid.



Variations

Consider creating leaves with colors other than Ming Green and Citron.

Beautiful combinations include:

- 10% fine Tangerine and 90% fine Clear frit, with Light Orange, Cherry Red, and Black powder accents.
- 70% fine Pale Amber and 30% fine Medium Amber, with Black powder accents.

- 10% fine Moss Green and 90% fine Clear, with Back and Dark Green powder accents.

Consider casting the piece thicker and not slumping it to create beautiful service pieces for hors d'oeuvres and cheeses.



Multiple Leaf Tack Fusing Schedule*

Segment	Ramp	Temperature	Hold
1	200°F/110°C †	300°F/150°C	10 minutes
2	200°F/110°C †	1000°F/535°C	30 minutes
3	200°F/110°C †	1200°F/650°C	45-60 minutes
4	100°F/60°C	1250-1260°F/675-680°C	10 minutes
5	AFAP	960°F/515°C	180 minutes
6	50°F/30°C	800°F/425°C	0 minutes
7	100°F/60°C	600°F/315°C	0 minutes
8	200°F/110°C	100°F/40°C	Off. No venting

Combined Multiple Leaf Slumping Schedule*

Segment	Ramp	Temperature	Hold
1	80°F/45°C ††	300°F/150°C	30 minutes
2	80°F/45°C ††	1000°F/535°C	85 minutes
3	50°F/30°C	1200°F/650°C	5 minutes
4	AFAP	960°F/515°C	180 minutes
5	50°F/30°C	800°F/425°C	0 minutes
6	100°F/60°C	600°F/315°C	0 minutes
7	200°F/110°C	100°F/40°C	Off. No venting

* Schedule for COE 96. For COE 90, increase casting temperature by 15°F/8°C. AFAP means "As Fast As Possible", no venting.

† Schedules were developed for side element kilns. Slow ramps by 50°F/30°C for top element kilns.

†† Slow ramps by 30°F/15°C for top element kilns and more than three leaves.